

Work Order ID 70423

Tuesday, June 07, 2011 1:41:31 PM



Page 1

Item ID: D4038-12

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 6/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date:

11/06/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

E

100

0.00



Bandsaw

0.00

Jeaspa Bandsaw

Memo

CUT BLANK 2.00" LONG

11/06/08

10

105

0.00



HAAS 1 Pirsch
HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA886

DWG REV:

FOLIO REV:

DEBURR

issue 710, 14260

CL

11/06/09

10

Dan's precision machine as
per dwg D4038 REV.E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



QC
Quality Control

~~QC2~~ Inspect parts off machine FAI/FAI-B

0.00

Memo

0.00

used + inspect for transit damage
attached c/c to w/o

6/6/22 (10)

120



QC
Quality Control

~~QC2~~ Inspect parts - second check

0.00

Memo

0.00

Sub 6/30

(XO)

130



HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10 @ 6/11-7-11

W/O:		WORK ORDER CHANGES					
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Required Date: 6/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10x Ø M 11/07/04

160

Identify as per dwg & Stock Location: 115

0.00



Packaging

Memo

0.00

Packaging

11/7/4 1228

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/4 1228

CZ 11/07/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, June 07, 2011 1:41:28 PM

Page 1

Work Order ID: 70423

Parent Item: D4038-12

Parent Item Name: Block



Start Date: 6/7/2011

Required Date: 6/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No				f	24.7077		1.747368			
6061-T6 Bar 1.50 x 2.00													

Location	Loc Qty	Loc Code
MAT010	24.70768	
110167	0.65	
114608	4.05768	
117933	20	

2.1 ~~10~~ 11/06/08

D4038-12P

Pickup 10

Dart Aerospace Ltd

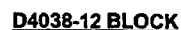
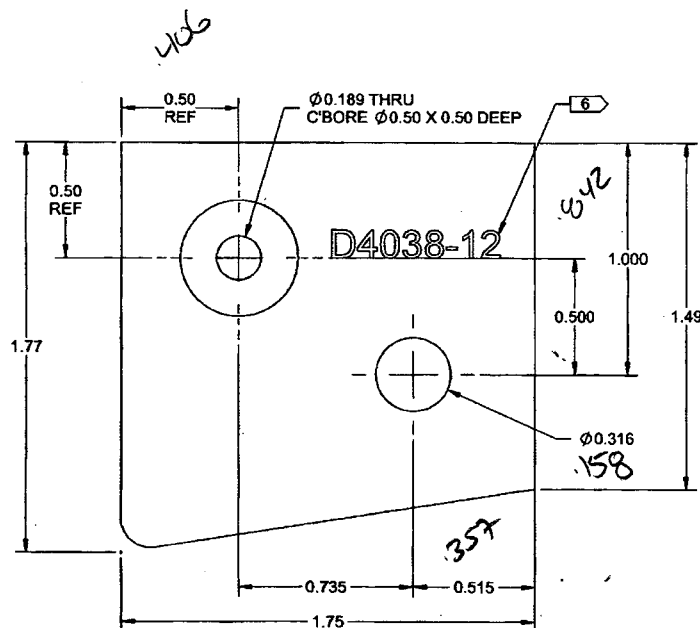
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CL1106107
W10:70923

RELEASE
2011-04-21

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
7) WEIGHT: 0.34 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4038	REV. E
MFG. APPR.			SHEET 14 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE 11.04.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD THE GOVERNMENT OF CANADA AND CONFIDENTIAL RIGHTS ARE RESERVED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

Dart Aerospace Ltd

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DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 27-Jun-11

Purchase Order : PO14260

Packing Slip : 10529

Part Number : D4038-12revE

Quantity : 10

8 u/06/30

Per: _____

For Dan's Precision Tools Inc.

DAN'S PRECISION TOOLS INC.

Customer: DART AEROSPACE

P.O.: PO14260

W/O: _____

Part #: D4038-12 rev E

Bracket, Block

Qty: 10

1 of 1